Vork Order ID 103951 , fonday, July 08, 2013 12:46:45 PM		*	1039	951,*				Page 1			
em ID: D2940-1 evision ID: em Name: Support	A	Accept		*N900	<b>040</b>	100	)* s	etup Star Sto	1/1	S1* S2*	
tart Date: 7/8/2013 Start Qty: 20.00 Required Date: 7/31/2013 Req'd Qty: 20.00 Reference:	*20* *20*		"	Cust Item I	D:						
pprovals: Process Plan:QC:			•	2	ite:		, ,		un Start *NF Stop *NF		
equence ID/ Operation Vork Center ID Description		Set l Run	Jp/ Hours	Tool ID	Tool #	Pian Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr Revision Nbr								,			
D2940 C											
00 *100* HAAS CNC VERTICAL M HAAS I Memo	IACHINING #1	0.00	Fe	2013-07-7	27		20	φ	·- <del></del>	····	
IAAS CNC vertical machine #1 I-Machine as p 2-Deburr	er Folio FA079	: '							•		
10 QC2- Inspect parts off mach	hine FAI/FAIB	0.00	·							4.	
*110* QC Memo Quality Control		0.00	FC	2013-07-2	.7		<u> 20</u>	<u>\$</u>			
20 QC8- Inspect parts - second	i check	0.00	<b>k</b>	12/00/0	a.	Ť		,		DAS 08	
*120* QC Memo Quality Control		0.00	Δ.,	15/00/0	<i>م</i> ا		20_	<u> </u>		08	

DQA:	WORK ORDER NON-CONFORMANCE / UPDATE										"D'A DT			
o k ol		D-4-	,		WORK ORDER NON	-C(	ONFO	RMANCE / UI		187	ante Ondon es	برامغم مجارر		AEROSPACE
QA Closed:		Date								VV	ork Order up	odate only	<u> </u>	
Work Orde	er:	•			DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
					Rework	1		Skid-tube	Crosstube			Water Jet		Engineering
Part N	10.			!	Scrap	1		Machining	Small Fab		Pro	d. Eng. Coor.	$\vdash$	Quality
					Use-as-is	1 !		noforming	Finishing		l	re/Packaging		Other
NCR N	lo				Suspected Unapproved	]		Large Fab	Composite			Supplier		
Root				Desc	I ription of work order update		I Initial	Act	ion		Sign &			
Cause	Dat	e Step	Qty		or non-conformance	Ch	nief Eng	Descr	iption	_ I		Verificatio	n	QC Inspector
Design						Î								
Doc/Data				i										
Equip/Tooling														
Handling/Pre											!			
Material		-												
Operator						1								
Offset/Setup														
Process						1								
Supplier		İ			•								•	
Training						1								
Transport			l											
Unapproved				<u> </u>		<u> </u>		<u> </u>						
<u>.                                    </u>						FA	ULT CA	TEGORY						
Landir	ng Gear			_	General		1 .		1		1			1
	Bendi	_		<u> </u>	Bend	$oxed{oxed}$	-{	Program			Outside Dim		<u> </u>	Pressure/Forced
	<del></del>	Not Conc	entric	-	BOM/Route	$\vdash$	Grain	26	i		Over/Under		<u> </u>	Set-up
	Cracks				Broken/Damage/Defect	<u></u>	Hardwa				Part Incorred		_	Temperature/Cure
		/Kink/Ripp	le/Wave	<u> </u>	Burrs	$\vdash$	- i	ion Incomplete/Ur		_	Part Lost/Mi	ssing	_	Weld
,	Cuffs			<u> </u>	Contamination	-	4	tions Incomplete/U	Jnclear		Part Moved			Wrong Stock Pulled
ļ	Crush	-			Countersink	$\vdash$	1	gned/off center		_	Positioned V	_	_	1
	Heat			<u> </u>	Cut Too Short	<u> </u>	Mislabe				Power Loss/	Surge		Other
		tion Strip i	n Tube	<u> </u>	Drawing	$\vdash$	Misread				<del> </del>	· .		
		/Chatter		<u> </u>	Drill Holes	$\vdash$	Off-set				·			
		g Sequenc		<u> </u>	Finish	$\vdash$	1	Calibration						
	Wave/Twist in Tube			ı	Fit/Function	1	IOut of 9	Sequence						

H:/FORM\$/Quality Assurance\approved QA/NCRWO RevH

Work Orde Monday, July 08		3951		*103	951*					<del></del>	Page 2	·
Item ID: Revision ID:	D2940-1	9.43 F.M	,	Accept	*N900	<u>0</u> 40	100	)* s	etup Start	IV	S1*	<b>⇒</b> -
Item Name: Start Date: Required Date: Reference:	Start Date: 7/8/2013 Start Qty: 20.06 Required Date: 7/31/2013 Req'd Qty: 20.06 Reference: Approvals: Process Plan:		*20* *20*		Cust Item 1 Customer:	ID:			Stop	IV	S2*	
QC:Sequence ID/ Work Center ID		an:			Date:			Run Start Stop			*NR1* *NR2*	
		Operation Description		Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number		
*130* HandFXtube Hand Finishing Cro	osstubes		cotch-Weld as per dwg.	0.00 rep inner concave surface of	support and			90	<u> </u>		13-8-8	>
140 <b>*14 QC</b> Quality Control		QC5- Inspect part comple	eteness to step on W/O	0.00				10			* DAS . <b>05</b>	B-08.08
170 *170* Packaging		ldentify as per dwg & Sto	ock Location: <u>LG 5</u> 2	0.00				30			<u>AJ</u> 13-8.	
Packaging		1724110			- 1						13-8.	7

DQA:		Date:								TOAPT		
QA Closed:		Date:			WORK ORDER NON-	-C(	ONFO	RMANCE / UPDATE	w	ork Order us	ndate only	AEROSPACE
					DISPOSITION			4.0.1110		· - · · ·		
Work Orde	er:				DISPOSITION			AGAINS	וטנ	PARTMENT	/PROCESS	
				_	Rework			Skid-tube Crosstub	e		Water Jet	Engineering
Part N	No				Scrap			Machining Small Fa	b	Pro	d. Eng. Coor.	Quality
					Use-as-is		Thern	noforming Finishin	g[_	Rec/Sto	re/Packaging	Other
NCR N	No				Suspected Unapproved			Large Fab Composit	€	]	Supplier	
Root		T	<u> </u>	Desci	ription of work order update		Initial	Action		Sign &		
Cause	Date	Step	Qty		or non-conformance	ı	ief Eng	ľ		Date	Verification	QC Inspector
Design												
Doc/Data												
Equip/Tooling						•						
Handling/Pre						İ						
Material												
Operator				<b>;</b>								
Offset/Setup				1								
Process						İ						
Supplier						ĺ						
Training												
Transport												
Unapproved						<u> </u>				<u> </u>		<u> </u>
						FAI	ULT CAT	regory			. <u></u>	<u> </u>
Landii	ng Gear			_	General				_	-		_
	Bending				Bend	_	Folio/P	rogram		Outside Dim	ensions	Pressure/Forced
	Centre N	ot Concer	ntric	_ —	BOM/Route		Grain		L	Over/Under	tolerance	Set-up
	Cracks				Broken/Damage/Defect	<u> </u>	Hardwa	re	_	Part Incorred	ct	Temperature/Cure
	Crimp/Kii	nk/Ripple	/Wave		Burrs		Inspecti	ion Incomplete/Unqualified		Part Lost/Mi	ssing	Weld
	Cuffs			<b>⊢</b>	Contamination	_	instruct	ions Incomplete/Unclear	L	Part Moved		Wrong Stock Pulled
	Crushing			<u> </u>	Countersink		Misalig	ned/off center		Positioned V	Vrong	_
	Heat Trea				Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other
	Inspectio		Tube		Drawing	Щ	Misread	i				
;	Marks/Ch				Drill Holes		Off-set					
	Turning S			<u> </u>	Finish	-	1	Calibration				
	Wave/Twist in Tube				Fit/Function		Out of S	sequence				

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Work Orde Monday, July 08,				*10.3	951*	<u> </u>						Page
Revision ID:	D2940-1 Support			Accept	*N900	<u>040</u>	100	)*	Setup	Start Stop	ı VI .	S1* S2*
Start Date: Required Date: ' Reference:	7/8/2013 7/31/2013	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*		Cust Item I Customer:	D:					ı u.	
Approvals:	Process Pla	an:	Date:	Tooling:		 ite:			Run	Start	I <b>V</b> I	R1*
	QC:		Date:	SPC (Y/N):	i i	nte:				Stop	*N	R2*
Sequence ID/ Work Center ID		Operation Description QC21- Final Inspection -	Work Order Release	Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
*180* QC Quality Control		Мето		0.00				M\	ヹ_	<u>13-</u> e	13-13	 ع8-12

DQA:		_	Date:			WORK ORDER NON-CONFORMANCE / UPDATE								
QA Closed:			Date:	,		WORK ORDER NON-CONFORMANCE / UPDATE  Work Order update only								
		· · .				DISPOSITION				· <del>-</del>	EPARTMENT,		<del>_</del>	-
Work Ord	er: _					DISPOSITION				AGAINST D	EPAKTIVIENT,	PROCESS _		
			-			Rework			Skid-tube	Crosstube		Water Jet	Engineering	
Part I	۷o.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality	
						Use-as-is		Therr	noforming	Finishing	Rec/Sto	re/Packaging	Other	
NCR I	No					Suspected Unapproved		Ì	Large Fab	Composite		Supplier		
Root	$\neg$				Desc	ription of work order update		Initial	Actio	on	Sign &		<u> </u>	_
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Descri	ption	Date	Verification	QC Inspector	
Design											Ì			_
Doc/Data						•								
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Handling/Pre				•	ļ									
Material														
Operator	Ш					i	1							
Offset/Setup	Ш													
Process	Ш		:			t								
Supplier	Ш		!											
Training	Ш													
Transport	Ц													
Unapproved							_							_
		_					FA	ULT CA	regory					_
Landi						General		,		_	_	_		
	Н	Bending	•			Bend	匚	1	rogram 'rogram'	<u> </u>	Outside Dim	<b>—</b>	Pressure/Forced	
	_		ot Concer	itric	_	BOM/Route		Grain		L	Over/Under	tolerance	Set-up	
	$\vdash$	Cracks				Broken/Damage/Defect	<u> </u>	Hardwa	ire	_	Part Incorred	<b>⊢</b>	Temperature/Cure	
	Ľľ	Crimp/Kir	ık/Ripple,	/Wave	ļ	Burrs	<u>L</u>	Inspect	ion Incomplete/Unc	qualified	Part Lost/Mi	ssing	Weld	
	${f H}$	Cuffs			<u> </u>	Contamination		4	ions Incomplete/Ur	nclear	Part Moved	Ŀ	Wrong Stock Pulled	
	⊢:	Crushing			<u> </u>	Countersink	_	Misalig	ned/off center	L	Positioned V	_	<del>-</del> -,	
	—~	leat Trea				Cut Too Short		Mislabe		L	Power Loss/	Surge	Other	_
	${f}$	•	n Strip in	Tube		Drawing	<u> </u>	Misread	i .					_
	${f H}$	Marks/Ch	· H				Off-set						_	
	$\boldsymbol{\vdash}$	Furning S				Finish	Out of Calibration						_	
	Wave/Twist in Tube					Fit/Function		Out of 9	equence					

Required Date: 7/31/2013

Required Qty: 20.00

Monday, July 08, 2013 12:46:55 PM

Work Order ID: 103951

\*103951\*

Parent Item:

D2940-1

\*D2940-1\*

Parent Item Name: Support

Comments:

C 02.11.26Reformat; Added P/OKJ IPP

IPP Rev:D Added priming as per Rev B 07-04-30 JLM 08.03.19 Re-format Ec verified by DD

IPP Rev:F 08-10-22 add qc14 DD verified by:EC

IPP Rev:G

11.08.04 as per dwg rev.C DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSK081		Manufactured	No			110	Each	11.0000	0.5	10.52632			
*DSK081*									**		T	> -07	-()

<u>Location</u>	oc Oty	Loc Code
MAT060	11	
101402	10	
88241	1	

Start Date: 7/8/2013

Start Qty: 20.00

DQA:		Date:			- Wask appendion consorrance (Uppare									
			•		WORK ORDER NON	-CC	ONFO	RMANCE / UPDATE					AEROSPACE	
QA Closed:		Date:		-	<u> </u>		1	<u></u>	W	ork Order up	odate only		<del> </del>	
Work Orde	r:				DISPOSITION			: AGAINST	DE	PARTMENT	/PROCESS			
Part N NCR N	0.			<del></del>	Rework Scrap Use-as-is Suspected Unapproved			Skid-tube Crosstube  Machining Small Fab  noforming Finishing  Large Fab Composite		-	Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other	
Root	)			Desci	ription of work order update		nitial	Action		Sign &				
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	1	QC Inspector	
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved		Date Step Qty												
						FAI	ULT CAT	TEGORY						
Landin	<del></del>			,	General	_	1		_	<b>a</b>	·			
- - - - - - - - - - - - - - - - - - -	Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence				Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspecti Instruct Misalig Mislabe Misread Off-set	ion Incomplete/Unqualified tions Incomplete/Unclear gned/off center eled		Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ct sssing Vrong		Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other	
•	Turning Sequence Wave/Twist in Tube				Fit/Function	<b></b> -	4	Sequence			<del></del>			

DART AEROSPACE LTD		Work Order:	103951
Description: Ø3.250 Support		Part Number:	D2940-1
Inspection Dwg: D2940	Rev: C		Page 1 of 1

		IINSI	ARTICLE INS	г			I	
			X First A	Article	Proto	type		
					Record	Actual Dime	ensions	
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
			1	HAAS Section	on			
AA	0.240	0.260		0.250	0,250	0.250	0250	0.250
AB	0.490	0.510		0.500	0.500		0.500	0.500
AC	0.140	0.160		0.154	0.154	0159	0.154	0 154
AD	3.510	3.530		3.3(0)	3,515	015H	3.514	3.514
AE	1.633	1.673		1.657	1.654	1.657	1.455	I CF La
AF	1.493	1.513		1,510	1.504	1.505	1.504	1506
AG	0.040	0.060		0.050	0.050	0050	0.050	C.050
AH	0.188	0.193		0.189	0.190	0.190	0190	0.190
Al	0.140	0.160		0.153	0.153	0.157	0.157	0.151
AJ	2.518	2.538		7.526	2.526	2.526	2.524	2.523
AK	0.040	0.060		0050	0.050	02050	0.050	0050
AL	9.010	0.020		0.015	005	0.015	0.05	0.015
AM	0.140	0.160		0.154	0.151	0.53	0183	0:153
AN	0.350	0.450		0.400	0.400	0.400	0.400	0.400
AO	0.240	0.260		0.250	0.250	6.250	0.2.50	
AP	0.150	0.170		6-155	0.153	0.155	0,155	01220
- AQ -	0.053	0.073		0.063	0.063	0.063	0003	Øα03
AR	101.64	105.64		103.64	103,64	10367	103104	103.60
AS	0.260	0.267		0.2625	0363	0263	0763	0.56
AT	0.053	0.073		0.663		0 803	0.063	0.00
AU	4.118	4.138		4.125	9.063	4.128	4,175	4125
AV	7.110_	7.100		4.162	7.126	1:1.03	7.125	1-1/12/3
AW	<u> </u>			<del></del>			<u> </u>	<del> </del> -
/111	<u> </u>	<u> </u>	Accept/Reject	<u> </u>				<del>                                     </del>
				_ <del></del>	-I			
	Measure	d by: JFC	,			Date:	2013-0	o7 -28
					AS	,	<del></del>	
	Audite	d by:   ይይ			) <u>8</u> -89	Date:	13/08/	06
Proto	type Appre	oval:			<u> </u>	Date:		
							·	
Rev	Date	Change					vised by	Approved
Α	02.12.12	New Issue		····			/RF	
В	07.05.08	Dwg Rev. up					/JLM	
С	07.07.18	Dimension A	S revised				/JLM	
Ū	08.04.22	Reformat					JLM JLX	<u> </u>
E	12 01 31	Dwg Rev up	datad			K.I	T" NUb	**

12.01.31 Dwg Rev. updated

DQA:		_ Date:			ΔART									
OA Clasadi		Data			WORK ORDER NON	-CC	ONFO	RMANCE / UPDATE	14/-	anta Ondina	.data amb	AEROSPACE		
QA Closed:		Date:			· · · · · · · · · · · · · · · · · · ·				VVC	ork Order up	odate only		-	
Work Order	·;				DISPOSITION			AGAINST	DEF	PARTMENT	/PROCESS			
				_	Rework	1 <b>1</b>		Skid-tube Crosstube	П		Water Jet	Engineering		
Part No	<b>)</b> .				Scrap	<b> </b>		Machining Small Fab	-	Pro	d. Eng. Coor.	Quality		
					Use-as-is		Therr	moforming Finishing			re/Packaging	Other		
NCR No	o				Suspected Unapproved	]	•	Large Fab Composite			Supplier			
			<del>, ,</del>		•								_	
Root				•	otion of work order update	1	nitial	Action		Sign &				
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector	_	
Design	_	1			i									
Doc/Data	_								ļ	•				
Equip/Tooling									ĺ					
Handling/Pre	_				ı	ļ								
Material	<del>-</del>											,		
Operator														
Offset/Setup	_						-				-			
Process	4								ĺ					
Supplier									İ	<i>ን</i> ` ን			•	
Training .	4									•				
Transport	4	1						•				,		
Unapproved								TCCOPY				·	_	
1	<i>,</i>					FAL	JET CA	regory				<u>-</u>	-	
Landing	<del></del>			$\Box$	<b>General</b> end		ralia/r	)rogram	Г	Outside Diss	:	Dragouro/Forgod		
-	Bending Centre No	at Cancar	atric	-	OM/Route	-	Grain	Program	$\vdash$	Outside Dim Over/Under	<u>-</u>	Pressure/Forced		
<u> </u>	Cracks	ot concer	ittic	<b>⊢</b> —	roken/Damage/Defect	ш	Hardwa			Part Incorre		Set-up Temperature/Cure		
<u> </u>	Crimp/Kii	ok/Rinnlo	Λειονο	<del>-</del>	urrs	┝━┤		ion Incomplete/Unqualified	$\vdash$	Part Lost/Mi	<b>├</b>	Weld		
<u> -</u>	Cuffs	ни кірріе	/ wave	$H_{c}^{\circ}$	ontamination	${f -}$		tions Incomplete/Unclear	Н	Part Moved	2311.fg	Wrong Stock Pulled		
-	Crushing			$H_{c}$	ountersink	—		gned/off center		Positioned V	trong _			
<u> </u>	Heat Trea			-	ut Too Short		Mislabe		-	Power Loss/	· · · -	Other		
<b>∳</b>	Inspectio		Tuhe	$\rightarrow$	rawing	-	Misread		Ш	i Ower coss/		Jones	-	
 	Marks/Ch	· .			rill Holes	$\vdash$	Off-set		•		·	<del></del>		
<u> </u>				$\vdash$	inish	ш		Calibration	•					
<u></u>	Turning Sequence Wave/Twist in Tube				it/Function	${m -}$		Sequence			<del></del>			

DART AEROSPACE LTD		Work Order:	103951		
Description: Ø3.250 Support		Pärt Number:	D2940-1		
Inspection Dwg: D2940	Rev: C		Page 1 of 1		

## FIRST ARTICLE INSPECTION DIMENSION SHEET

		FIRST	ARTICLE INS	SPECTION	DIMENSI	ON SHEET		*,			
			X First A	\rticle [	Proto	type					
Record Actual Dimensions											
Dim	Min	Max	Go/No Go Gauge	6	<b>z</b> 7	.38	#9	10			
			·	HAAS Sectio	n		<u> </u>				
AA	0.240	0.260		0.250	0.750	0.250	.250	250			
AB	0.490	0.510		0.500	0.530	ဝနယ	.500	.500			
AC	0.140	0.160		0.150	0.150	150	(50)	1570			
ΑĐ	3.510	3.530		3-514	3.54	3.570	3.572	1673			
ΑE	1.633	1.673		1.656	1,55	1.6.51	1.657	1.656			
AF	1.493	1.513	<u> </u>	1.500	1.500	1.500	1.507	1.505			
AG	0.040	0.060		0.050	0080	0.050	,057	054			
AH	0.188	0.193		0.190	0 190	0.190	MA	IAD			
Al	0.140	0.160		0153	0.153	0.53	1112	148			
AJ	2.518	2.538		2.572	5.526	3 6 30	2.518	2 520			
AK	0.040	0.060		9050	0.052	0050	·050	.050			
AL	0.010	0.020		0015	005	0015	.015	.015			
AM	0.140	0.160		0.149	0.151	.145	1140	.145			
AN	0.350	0.450		0.490	0 4072		.385				
AO	0.240	0.260		0. <b>18</b> 0		0.400	257	1400			
AP	0.150	0.170		0-150	0121	0.250	122	250			
AQ	0.053	0.073		0.063		./57	121	1/57			
AR	101.64	105.64			0.063	0003	103.64	.063-			
AS	0.260	0.267		103.64	103.64	103/04	703.69	103.64			
AT	0.053	0.073		0.26.2	0.262	202	413	242			
AU	4.118	4.138		6 333		0.003	:063	663			
AV	7.110	7.100		7.121	4.127	.4/28	96/25	4.125			
AW	<del> </del>			<del>                                     </del>			· · · -	<del> </del>			
,,,,,	<u>.l.</u>		Accept/Reject				·				
				1		•		<u> </u>			
	Measure	d by: SFC	, Jony			Date:	2013-07	-29			
	Audite	- h			<del>\</del>	1 -	771.21				
	Audite	d by: りゅ	<u> </u>	<u>o</u>		Date:	13/08/	26			
Proto	type Appr	oval:		<u> </u>	89	Date:					
Rev	Date	Change				· ;	ا المحمدات				
A	02.12.12	New Issue			vised by	Approved					
B	07.05.08										
C	07.03.08		Dwg Rev. updated KJ/JLM  Dimension AS revised KJ/JLM								
D	08.04.22	Reformat	) I CAIDEO	<del>-·</del>							
E	12.01.31	Dwg Rev. upo	hated	<del></del>			JLM JD				
	12.01.31	Dwg Kev. upo	aue0			KJ	YX\	M.			

DART AEROSPACE LTD		Work Order:	103951
Description: Ø3.250 Support		Part Number:	D2940-1
Inspection Dwg: D2940	Rev: C		Page 1 of 1

## FIRST ARTICLE INSPECTION DIMENSION SHEET

			X First A	Article [	Proto	type		
					Record	Actual Dim	ensions	
Dim	Min	Max	Go/No Go Gauge	1 (	12	t 3	1 4	15
			1	HAAS Section	n	<u> </u>	· · · · · · · · · · · · · · · · · · ·	<del></del>
AA	0.240	0.260		.250	250	. 250	,250	0.250
AB	0.490	0.510		.500	500	-500	- 574	0.500
AC	0.140	0.160		150	. 150	150	155	0.150
AD	3.510	3.530		3.520	3.520	3,520	3.520	3,520
ΑE	1.633	1.673		1.656	1.658	1.656	1/57	1.661
AF	1.493	1.513		1.502	1.505	1.561	1.501	1508
AG	0.040	0.060		1054	. 655	055	1053	0.053
AH	0.188	0.193	• • • • • • • • • • • • • • • • • • • •	190	190	.190	.190	0.190
Al	0.140	0.160	·	147	1147	144	146	0.150
AJ	2.518	2.538		2 528	2528	2528	3250	2528
AK	. 0.040	0.060		050	-050	050	.050	000
AL	0.010	0.020		015	015	015	0/5	005
AM	0.140	0.160		145	.145	.1345	145	0.150
AN	0.350	0.450		.400	400	400	.400	0.400
AO	0.240	0.260		.250	,250	. 2 572	250	0.750
ΑP	0.150	0.170	· · · · · · · · · · · · · · · · · · ·	1/53	153	153	.755	0152
AQ	0.053	0.073	<u></u>	101.3	.663	1063	1063	
AR	101:64			103 64-	103.64	7/13/14	103.64	103,04
A\$	0.260	0.267		21.2	262	2/2	31.3	Orloz
AT	0.053	0.073		.043	063	1043	· 0/2	0.003
AU	4.118	4.138		4/25	4.125	4.125	4/25	4.125
ΑV				1 / / ( 2 - 3	1.12.3	7.7~	1/123	7.163
AW			· · · · · · · · · · · · · · · · · · ·					<del> </del>
			Accept/Reject					
	Measure	i by:	VI TOTO	<u> </u>		Date:	13/07	·bi
					2AC	Date.	13/07	/3/
	Audite	d by:	·B		08	Date:	13 08	106
Proto	type Appr	oval:			2- <b>6</b> 3	Date:	<u> </u>	·
Rev	Date	Change				·		
	02.12.12	Change New Issue			vised by	Approved		
A B	07.05.08		lotod	_t			/RF	· · · · · · · · · · · · · · · · · · ·
C		Dwg Rev. upo					/JLM	<del></del>
<u> </u>	07.07.18	Dimension AS	revised			<b>K</b> J	/JLM	



KJ/JLM

KJ

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08.04.22 Reformat

12.01.31 Dwg Rev. updated



DART AEROSPACE LTD		Work Order: 103951				
Description: Ø3.250 Support		Part Number:	D2940-1			
Inspection Dwg: D2940	Rev: C		Page 1 of 1			

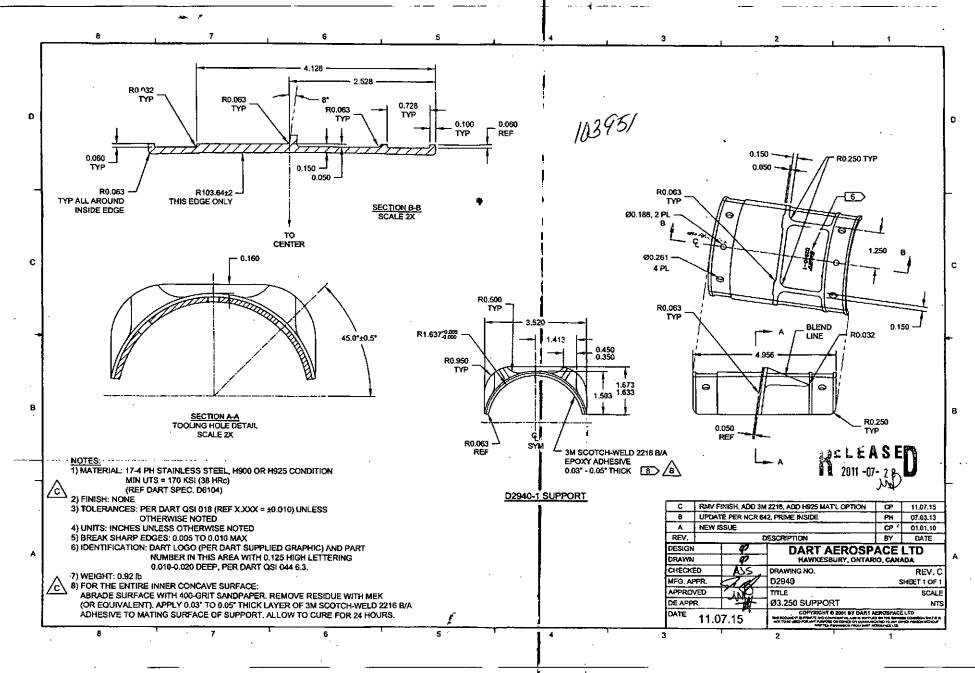
## FIRST ARTICLE INSPECTION DIMENSION SHEET

	X First Article Prototype									
Record Actual Dimensions										
Dim	Min	Max	Go/No Go Gauge	16	217	\$18	#19	820		
		<u> </u>	ł	IAAS Sectio	n		·	<u> </u>		
AA	0.240	0.260	· · · · · ·	0.250	0.250	0.250	0.520	0.250		
AB	0.490	0.510		0,500	0.500	0.500	0500	0.500		
AC	0.140	0.160		0.150	0.50	0.450	0.120	0127		
AD	3.510	3.530		3.520	3.518	3518	3.518	2.515		
ΑE	1.633	1.673	r.	1.659	1.658	1.659	1.657	457		
AF	1.493	1.513		1.508	1.507	1.807	1.505	1.501		
AG	0.040	0.060		0.052	0.00	0.049	0.031	0,050		
AH	0.188	0.193	1100	0.190	0.190	0.190	0.190	0.190		
Al	0.140	0.160		0.149	0.149	0,149	ก็เรอ	0.149		
AJ	2.518	2.538		2-528	2528	2528	2.5%	2528		
AK	0.040	0.060		0.000	0050	0.050	0050	0000		
AL	0.010	0.020		0-015	0.015	005	0015	0015		
AM	0.140	0.160		0.153	0.153	0.153	0.155	0153		
AN	0.350	0.450		0.400	0.400	0400	12400	0400		
AO	0.240	0.260		0.250	0.250	0.250	0.250	0 250		
AP	0.150	0.170		0.157	0153	0453	0.152	0.153		
AQ	0.053	0.073		തന്മ്	00003	0 5703	0000	0003		
AR	101.64	一105:64一		103.04	103.64	70364	1031M	103.64		
AS	0.260	0.267		0.2502	0.202	0262	(0262	0767		
AT	0.053	0.073		0003	0.003	0.000	0003	0.003		
AU	4.118	4.138		4.125	4.125	4.185	4125	4.125		
AV										
AW										
			Accept/Reject			<del></del>				

		-
Measured by: SFC		Date: 20/3/08/01
	2Å2	
Audited by: 5.a	0.8	Date: 3 08 06
	9-89	
Prototype Approval:		Date:

Rev	Date	Change .	Revised by Approved
. А	02.12.12	New Issue 👫	KJ/RF
В	07.05.08	Dwg Rev. updated	KJ/JLM .
C	07.07.18	Dimension AS revised	KJ/JLM
D	08.04.22	Reformat	KJ/JLM (A
Ē	12.01.31	Dwg Rev. updated	KJ day M

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DQA:			- Date:	*									TAKT
QA Closed:			Date:			WORK ORDER NON	ON-CONFORMANCE / UPDATE  Work Order update only						AEROSPACE
Mark Ord	or:			•		DISPOSITION		_		ÁGAINST D	EPARTMENT	/PROCESS	
Work Order:			<u> </u>	Rework Scrap Use-as-is			Skid-tube Crosstube Machining Small Fab		Prod. Eng. Coor.		Engineering Quality		
NCR I	No.					Suspected Unapproved	]		noforming Large Fab	Finishing Composite	Rec/sto	Supplier	Other
Root					Desc	ription of work order update		Initial	Act	ion	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	l .	•	Date	Verification	QC Inspector
Design			Î					H					
Doc/Data						•							
Equip/Tooling									-	_			
Handling/Pre	Ш					•					-		
Material	Ш							-					
Operator				<u> </u>					:	•		·	
Offset/Setup	Ц						Ι.	_	-				
Process	Ш	ř				•							
Supplier	Ш							•					
Training .													
Transport	Ш												
Unapproved	-												
_		·	_				FAI	ULT CAT	EGORY		·	<del></del> :	-
Landi	ng G	iear .				General		_		<u> </u>	_		_
		Bending			<u> </u>	Bend		Folio/P	rogram	i	Outside Dim	ensions	Pressure/Forced
w	Ш	Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance '	Set-up
	Ш	Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorred	ct	Temperature/Cure
	Ш	Crimp/Kir	nk/Ripple	/Wave	L	Burrs	L	Inspecti	on Incomplete/Un	qualified	Part Lost/Mi	ssing	Weld
		Cuffs				Contamination		Instruct	ions Incomplete/U	nclear	Part Moved		Wrong Stock Pulled
	Ш	Crushing				Countersink		Misalig	ned/off center		Positioned V	Vrong	_
		Heat Trea	it			Cut Too Short		Mislabe	led		Power Loss/	Surge	Other :
	Ш	Inspectio	n Strip in	Tube		Drawing		Misread	I	_			
		Marks/Ch	natter			Drill Holes		Off-set					
		Turning S	equence			Finish		Out of 0	Calibration				
		Wave/Tw	rist in Tub	e		Fit/Function		Out of S	equence				